

Sup 12/07

Dart Aerospace Ltd.









Date: Wednesday, 11/07/2007 6:30:28 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HOUSING WELDMENT
Job Number : 32219	
Estimate Number : 11874	
P.O. Number : <i>N/A</i>	Part Number : D2207041
This Issue : 11/07/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2207 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 03/05/2007 Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run :	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/05/2007 Qty: 5 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est. C 01.10.18 Added Step 10 and 11 SM	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D2208	End Cap
<div><div></div><div></div></div> <p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) End Cap Pick: Qty Part Number Description Batch 2 D2208 End cap <u>33239</u> 07/07/11 <i>SS</i></p>		
2.0	D22071	Housing
<div><div></div><div></div></div> <p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Housing Pick: Qty Part Number Description Batch 1 D2207-1 Housing <u>33240</u> 07/07/11 <i>SS</i></p>		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
<div><div></div><div></div></div> <p>Comment: LARGE FABRICATION RESOURCE 1 Weld as per Dwg D2207 Grind welds flush as per Dwg D2207 <i>Rod</i> <i>B102756</i> <i>16. 01. 07. 12</i> <i>SS</i> 07/07/11 <i>FF 07-07-12 - SAG 07/07/12</i></p>		
4.0	QC9	VISUAL WELDING INSPECTION
<div><div></div><div></div></div> <p>Comment: VISUAL WELDING INSPECTION <i>PD</i> 07-07-12 <i>(5)</i></p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(PTC)

Comment: LARGE FABRICATION RESOURCE 1

Drill holes using DT8557 as per Dwg D2207

FF 07-07-12 5

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 07/07/12 (5)

7.0

POWDER COATING

POWDER COATING



(5)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR 07-07-12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/07/12 (5)

9.0

ALS71032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Insert

Qty Part Number Description Batch

4 DAK57-1032-130 Insert

M6087

SB 07/07/12 (5)

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Install AK57-1032-130 as per Dwg D2207

FF 07-07-12

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/07/12 (5)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/07/12 (5)
07-07-12 (5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-07-12	5.0 5.1	Add QCS after drilling. Perm Change		07-08-12		07-07-12	07-07-12

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07-07-12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 32219

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5)

11/10/12

Job Completion



u 87-87-12



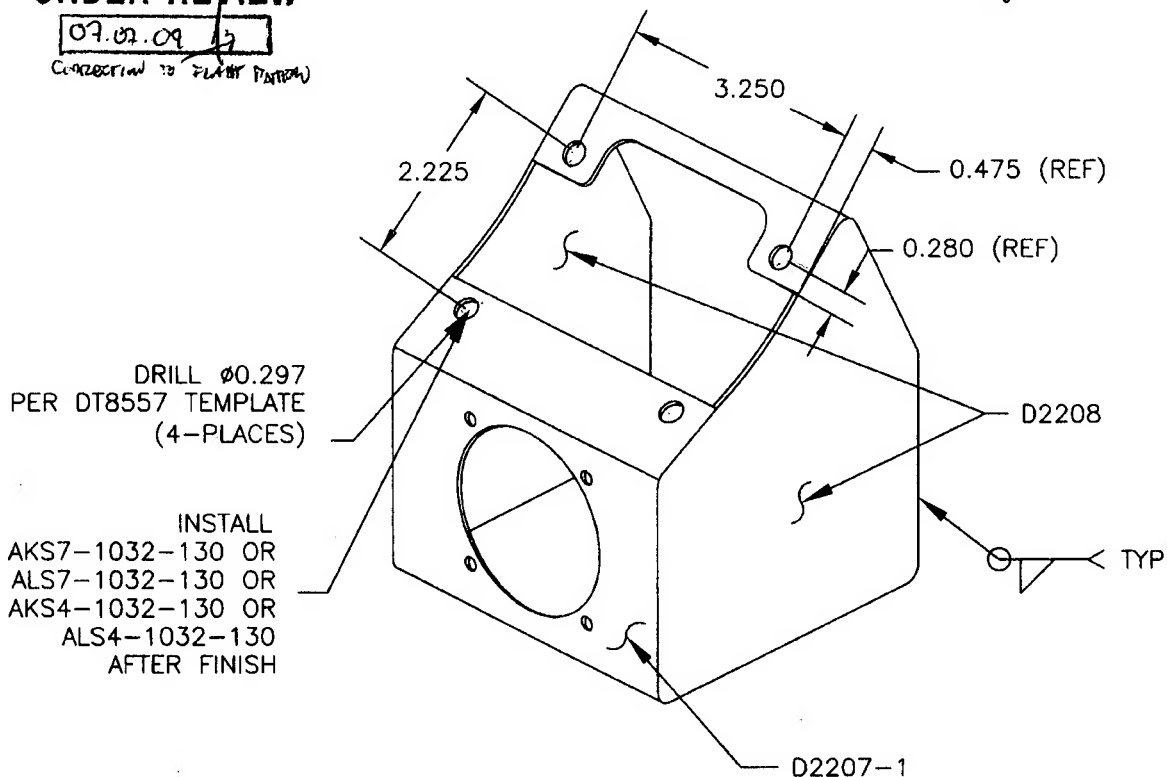
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2207	REV. B SHEET 1 OF 2
DATE 01.02.23		TITLE HOUSING	SCALE 1:2
A	94.09.01	NEW ISSUE	
B	01.02.23	REDRAWN	

RELEASED
01.02.27 #

UNDER REVIEW

07.02.09
CONNECTION TO FLAT PATTERN

W/03229



D2207-041 ASSEMBLY

NOTE:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT CLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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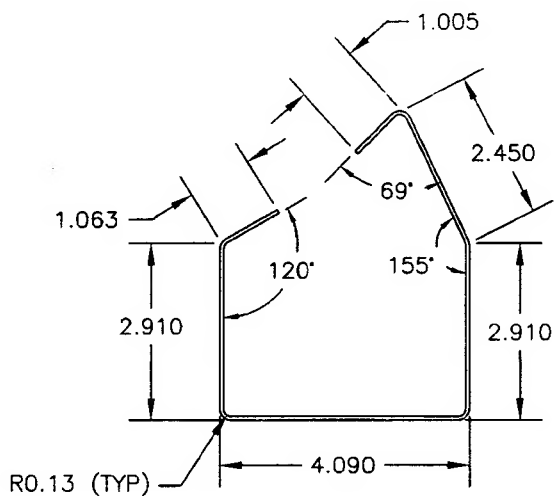
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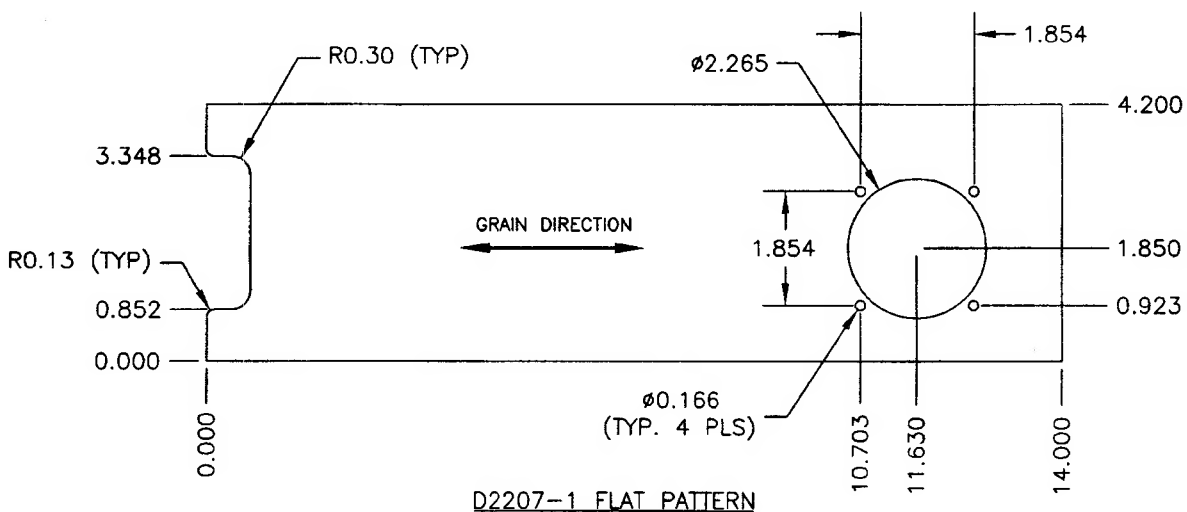
01.02.27 A

UNDER REVIEW

03.07.09
CORRECTION TO PLAT PARISH

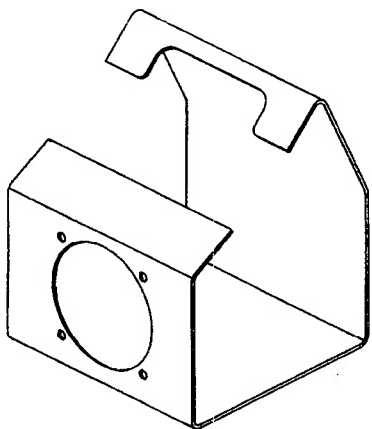


D2207-1 BENDING DETAIL





D2207-1 FLAT PATTERN

MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) ALUMINUM 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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CHECKED		APPROVED		DRAWING NO.	REV. B
DATE	01.02.23			D2207	SHEET 2 OF 2
				TITLE	SCALE
				HOUSING	1:3